Work Order ID 119755

Wednesday, May 21, 2014 1:39:17 PM

119755

Item ID: D4943-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: EAPS Flex Hose w/ 90° Connection **Stop** *NS2*

Start Date: 11/12/2014 **Start Qty:** 5.00 *5* **Cust Item ID:**

Required Date: 11/12/2014 **Req'd Qty:** 5.00 *5* **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 14/05/21 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4943	B

100 0.00

100

Purchasing

Purchasing

Memo 0.00

Issue P/O: 23323

Purchuse part #: 12EAS12S-03900F

Possible supplier: AERO-FLEX

Certificate of comformity is requirered

CL 14/05/21 5

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo 0.00

Certificate of comformity is requirered.

5x SP14-11-3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4943-1 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: EAPS Flex Hose w/ 90° Connection
Start Date: 11/12/2014 **Start Qty:** 5.00 *5*
Required Date: 11/12/2014 **Req'd Qty:** 5.00 *5*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				5			DAS 38 9-89 NOV 0 3 2014
120 QC Quality Control	**Memo**	0.00							
130	Identify as per dwg & Stock Location: SK220A	0.00				5x			DAS 46 9-89 NOV 05 2014
130 Packaging Packaging	**Memo**	0.00							
140	QC21- Final Inspection - Work Order Release	0.00					14/11/6		
140 QC Quality Control	**Memo**	0.00							

MF 14-11-05

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Rework ☐
Scrap ☐
Use-as-is ☐
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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

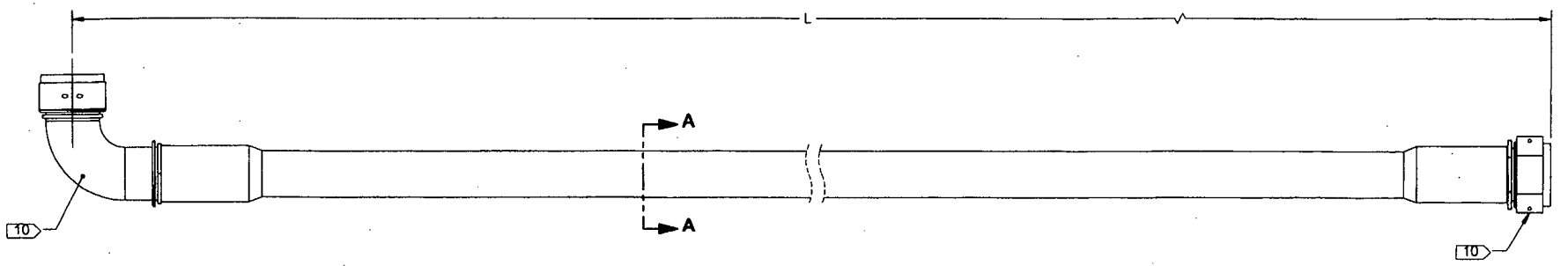
Landing Gear

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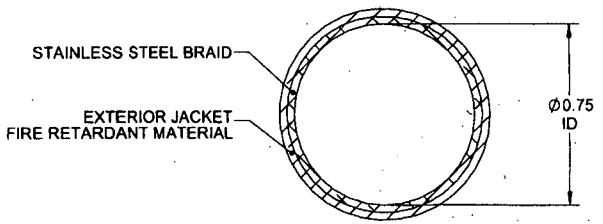
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

SPECIFICATION CONTROL DRAWING



D4943-XX FLEX HOSE



SECTION A-A
TUBE BUILD-UP

DART P/N	L	VENDOR	VENDOR P/N	WEIGHT	
D4943-1	40.00	AERO-FLEX	12EAS12S-03900F	1.3 lbs	B

CG 14/05/21
W10: 119755

RELEASED
2014 -05- 5

NOTES:
1) MATERIAL: BRAID: STAINLESS STEEL PER MANUFACTURER
JACKET: FIRE RETARDENT MATERIAL PER MANUFACTURER
END FITTING: STAINLESS STEEL PER MANUFACTURER
2) FINISH: N/A
3) TOLERANCES: N/A
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: PER QSI 044 6.1.
7) WEIGHT: SEE TABLE
8) MAXIMUM OPERATING TEMPERATURE 500 °F
9) MAXIMUM OPERATING PRESSURE 120 PSI
10) END FITTING REQUIREMENTS: FEMALE, 3/4, 37 ° JIC FITTING (THREAD 1-1/16 UN), WITH LOCKWIRE HOLES

REV.	DESCRIPTION	BY	DATE
B	SEE CHART: VENDOR WAS SWAGELOK, VENDOR P/N WAS SS-FJ12TA12AS12-40F. REASON: VENDOR CHANGED FOR LEADTIME ISSUES.	AJS	14.03.14
A	NEW ISSUE	AJS	13.09.18

APPROVED

DESIGN	AS
DRAWN	AJS
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.03.14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4943 REV. B
SHEET 1 OF 1
TITLE FLEX HOSE
SCALE NTS

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

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Part No. _____

NCR No. _____

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23323

Purchase Order Date 3/12/2014
PO Print Date 5/21/2014

Order From : VU-AFL001

AERO-FLEX CORP
3147 JUPITER PARK CIR
JUPITER, FLORIDA 33458
USA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 561-745-2534
Ship To Contact
Ship To Phone
Ship Via: FedEx Priority First collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA – (Free Carrier)

8	12EAS1S2-03900F	FLEX HOSE	11/12/2014 Yes 11/12/2014	FN	5.00 Each	✓	$499.00

Manufactuer as per drawing D4943
rev.B
B119755

Manufacture P/N 12EAS1S2-03900F

SP14-113

Line Total:

9	71401-45		11/12/2014 No 11/12/2014		0.00		$0.00

Quality Procurement Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total:

PO Total:

CL MG

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explaination.

Change Nbr: 7 **Change Date:** 5/21/2014

Aero-Flex Corp.
Jupiter, FL 33458
3147 Jupiter Park Circle

Phone# 561-745-2534 Fax# 561-745-2537
www.aero-flex.aero

Satisfied? Did you get Hosed?
Please complete Aero-Flex's
Satisfaction Survey located at
www.Aero-Flex.aero

Packing Slip

Certificate of Conformance

Date	Invoice #
10/28/2014	2305

Bill To	Ship To
Dart Aerospace Ltd 1270 Aberdeen Street Hawkesbury, ON K6A 1K7	

AF S.O. #	Customer P.O. #	Ship Date	Via	FOB	Project
PO23323	PO23323	10/28/2014	Federal Express		PO23323

Quantity	Item	Part Number/Rev	Description
5	8	12EAS1S2-03900F	EAPS Flex Hose With/90 degree Connection, drawing D4943-1 Rev B Tracking # 771647084503

8PK4-11-3

We hereby certify the above parts, including all materials, have been manufactured, tested and packed in conformance with all requirements of your order and the applicable government specifications and standards. Records of tests, inspections and certification indicating the above conformance are on file at Aero-Flex Corp. availabe for examination. It is hereby certified that any parts identified with TSO identification (a) were produced under Federal Aviation Administration (FAA) approved manufacturing and quality control system/methods as set forth in the FAA issued Technical Standard Order authorizations (TSO), and (b) such parts and/or materials are new and are in condition for safe operation. If applicable, satisfactory compliance with the conditions and tests required for TSO approval indicates the hose assembly has met the minimum performance standards in this TSO.

It is the responsibility of those desiring to install this hose assembly on an aircraft or engine to determine that the installation will not cause the hose assembly to be subjected to conditions in excess of those for which it has been approved. The hose assembly may only be installed in a manner acceptable to, or approved by, the Administrator.

The above commodities are subject to the Export Administration Regulations (EAR) and/or International Traffic in Arms Regulations (ITAR). If applicable, it is your responsibility to obtain a validated export license for this material from the Department of Commerce or the Department of State if so required under the applicable U.S. Govt. Export Control Regulation. The above material shall not be shipped to any country that has an embargo placed on it by the U.S. Govt or any entity on the U.S. Debarred list. By accepting the items on this PackSlip/C of C/Invoice you agree to Aero-Flex Corp's Terms and Conditions of Sale. These commodities, technology or software were exported from the United States in accordance with Export Administration Regulations. Diversion contrary to U.S. law is prohibited. These items may not be used directly or indirectly in prohibited nuclear, chemical, biological, or missile weapon activities.

Michael E. Scott
Michael E. Scott
Quality Manager

Form 4QF015-01
REV B

Aero-Flex Corporation
3147 Jupiter Park Circle, Ste. 2
Jupiter, Florida 33458
Ph 561.745.2534 Fax 561.745.2537

PRESSURE TESTING / HELIUM MASS SPEC EXAMINATION REPORT

☐ Aerospace ☑ Ground Support

TO: Aero-Flex Corporation	FROM: Jason Farris	DATE: 06/03/2014	
PROJECT: **AF Dwg:** 12EAS1S2-03900F **Dwg Rev:** - **Part:** 12EAS1S2-03900F **Part Rev:** -			
PURCHASE ORDER NO.: AF INVENTORY **Line** 1	AF ROUTER NO.: STK3445		
ITEM: ☑ Weld ☐ Castings ☑ Pipe ☐ Machined Parts	Other: Hose		
☑ Non-Weld ☐ Castings ☑ Pipe ☐ Machined Parts	Other: Hose		
MATERIAL: Size: 3/4"	No. of pieces: 21	Type of Base Metal: AUSS	Type of Filler Metal: P8
WELD: ☑ As Welded ☐ Smooth			
LOCATION: Location: Aero-Flex Corporation	System: PT-001		
AcceptanceStandard: CUSTOMER	Procedure: AF 2QP024		
TYPE OF CHECK: ☑ Initial ☐ In Process ☐ Rework ☐ 24 Hr ☐ 7 Day ☑ Final			
TYPE OF INSPECTION METHOD: ☑ Hydrostatic ☐ Pneumatic ☐ Bubble Test ☐ HMST-Pressurized Components ☐ HMST-Evacuated Components			
Test Pressure/Vacuum: 180	Test Temperature: 75°F Ambient	HMST Test Instrument: N/A	
Test Medium/Concentration: Potable Tap Water	Bubble Solution: N/A	HMST Standard Leak: N/A	
Gage Mfr.: McDaniel / Model: FIP-GF / Range: 0-3000 PSIG / ID Number: AFCG301		Tracer Gas/Concentration: N/A	
Soak Time/Test Holding Time: 10 Minutes Minimum		HMST Sensitivity Acceptance: N/A	

Reference Summary ☐ See Attachment

CUTOMER DRAWING

Results of Inspection

Satisfactory/Pass
No Leaks were Detected.

CopyTo: AF File	Requested By: PO Contract	Reported By: Jason Farris
	☐ Customer Specifications ☑ Accept ☐ Reject	Quality Designee: Mike Neimark Mn

NOTICE: THIS EXAMINATION REPORT IS A REPORT OF THE RESULTS OF THE TEST PROCEDURES ACTUALLY PERFORMED BY THIS COMPANY. IT IS SUBJECT TO THE LIMITATIONS OF THE TESTING SPECIFICATIONS AND PROCEDURES WHICH WERE UTILIZED. BY FURNISHING THIS REPORT, AERO-FLEX CORPORATION DOES NOT GUARANTEE ANY CONDITION OF THE TESTED SPECIMEN.

CERTIFICATE OF INSPECTION

QC Laboratories, Inc

HOME OFFICE
2870 Stirling Road • Hollywood. Fl 33020-1199
Ph 954 925-0499 • Miami 305 949-3166 • Fax 954 925-5851

	MAGNETIC PARTICLE
	ULTRASONIC
X	PENETRANT
	X-RAY
	EDDY CURRENT
	WELDING

DATE	06-05-14
COMPANY NAME	Aero-Flex Corp
ADDRESS	3147 Jupiter Park Circle
	Jupiter, FL 33458

6/10/14

PARTS LISTED BELOW APPLY ON YOUR P.O.	140604EH	QCL INV. No.	A140029	IDENTIFIED BY	CE	JOB No.	14F-1218

QUANTITY	PART NUMBER	DESCRIPTION	PART ACCEPTED	PARTS REJECTED
21	N/A	AF Router Stk3445/Dwg 12EAS1S2-03900F	21	0
		42 welds 0.75" dia (W1, W2)		

THE ABOVE LISTED PARTS HAVE BEEN INSPECTED AS PER: ***FPI per ASTM E1417/E1417M-13 Type I, Method A, Sensitivity Level 3, Form A. Accept per AWS D17.1 Class B.***

Q.C. Laboratories,Inc. Maximum Liability for loss(es) of any kind due to interpretation, is invoice charges

Q.C. LABORATORIES, INC
CERTIFICATE FAA REPAIR STATION #CD4R098M

Inspector

Cornelius Eafford Level II

FORM 200 REV 04/10